










Date: Thursday, 17/08/2006 3:17:40 PM
 User: Linda Lacelle


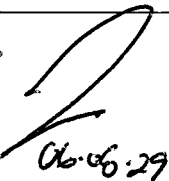

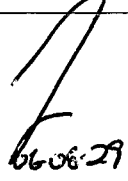
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 28213		
Estimate Number	: 10698		
P.O. Number	: N/A	Part Number	: D34631
This Issue	: 17/08/2006 S.O. No. : N/A	Drawing Number	: D3463 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 28192	Material	: N/A
Written By	: <u>W</u>	Due Date	: 31/08/2006
Checked & Approved By	: <u>W</u>	Qty:	5 Um: Each
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M316TR100W120	Inventory	
			
Comment: Qty.: 2.1872 f(s)/Unit Total: 13.1229 f(s) AISI 316 SS seamless tubing 1.00" OD X 0.120 wall (M316TR1.00w120) Batch: <u>M 101945</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blank 25.00 " long			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Bend as per dwg D3463 2-Trim to lenght per dwg D3463 3- Deburr			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.08.29	3	2 Trimed to short 2 scrap. Measured dim. off of square that the square. The square was 2" off.		Destroy. No mat'l to replace.	FF 06.08.29	 06.06.29		 06.06.29

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28213

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3463

2-Deburr as per dwg D3463

06/09/05

3

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/08/05

3

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/09/05 3

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 338*

06/09/07 (3)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07

Job Completion



u 06/09/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

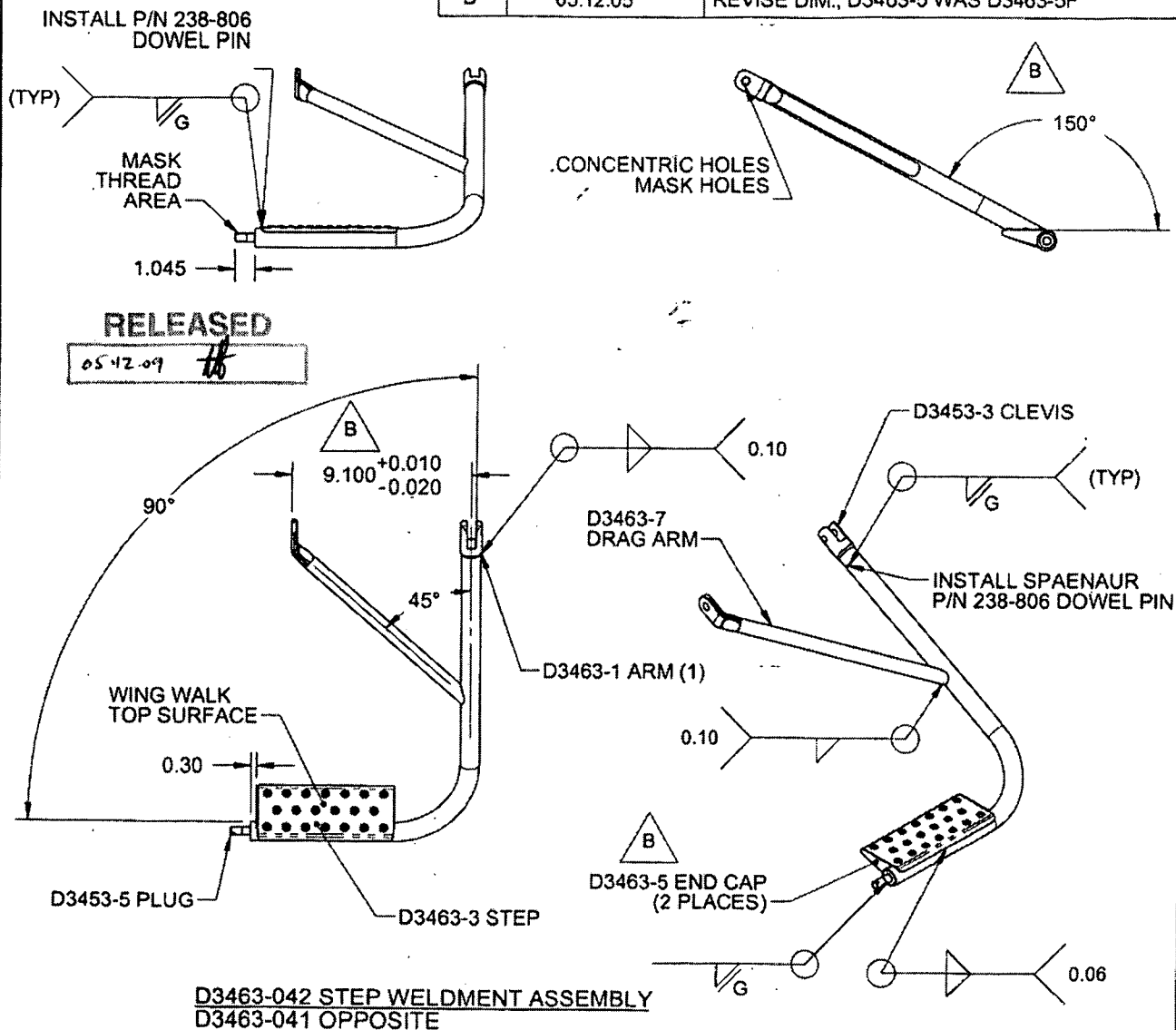
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

REFERENCE

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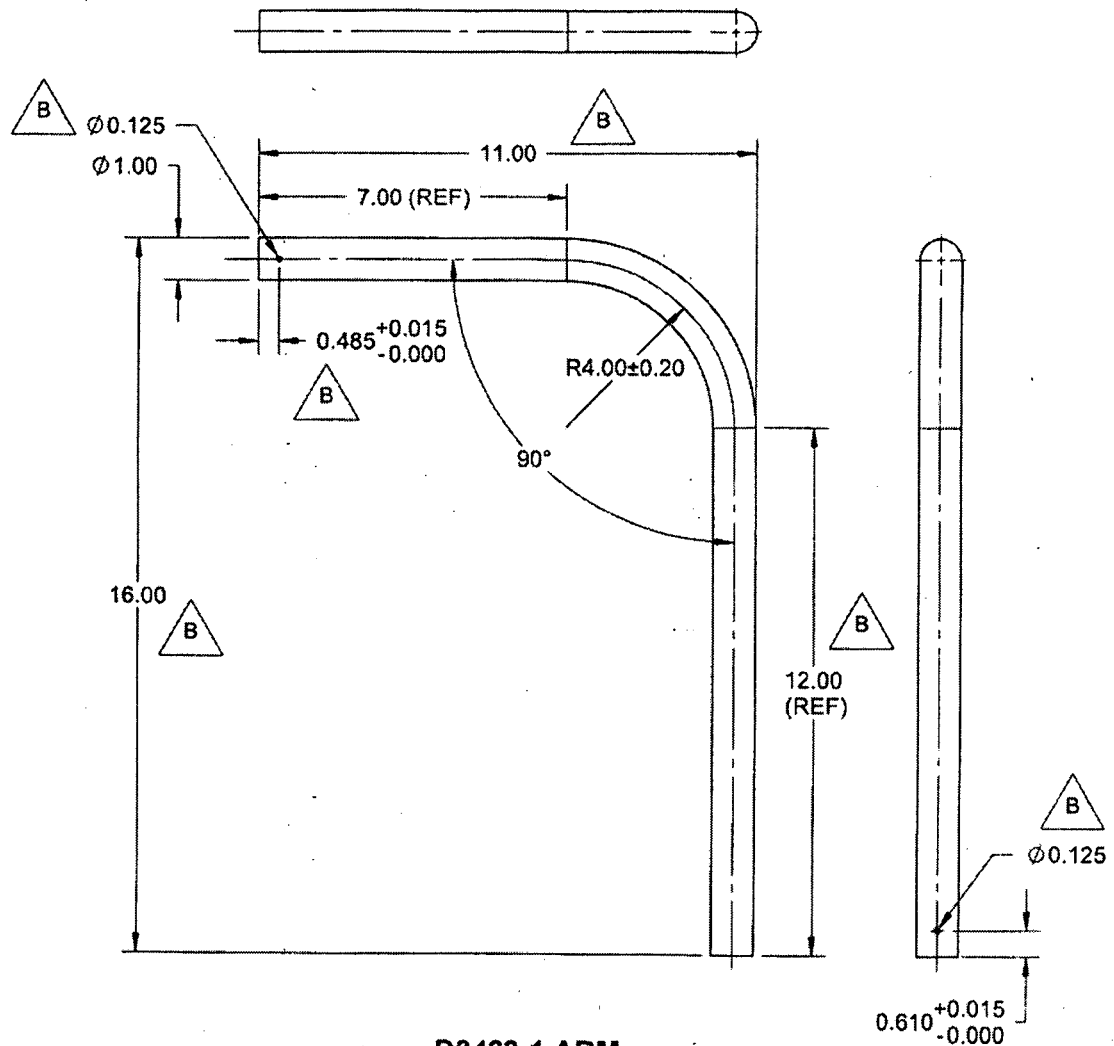
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

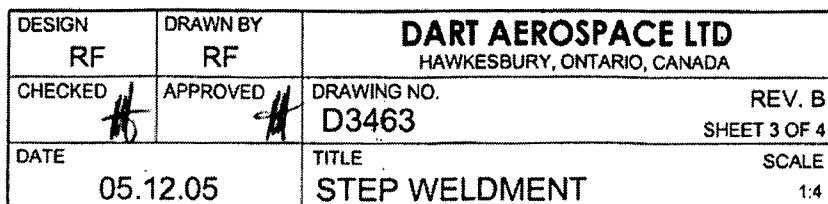
05.12.04 [Signature]

**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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05.12.04



- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

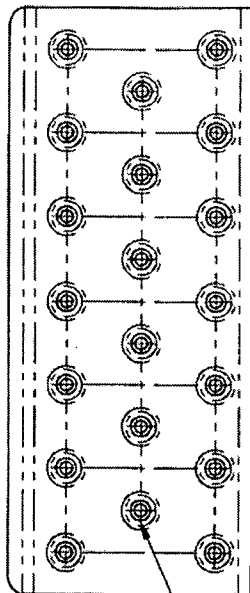
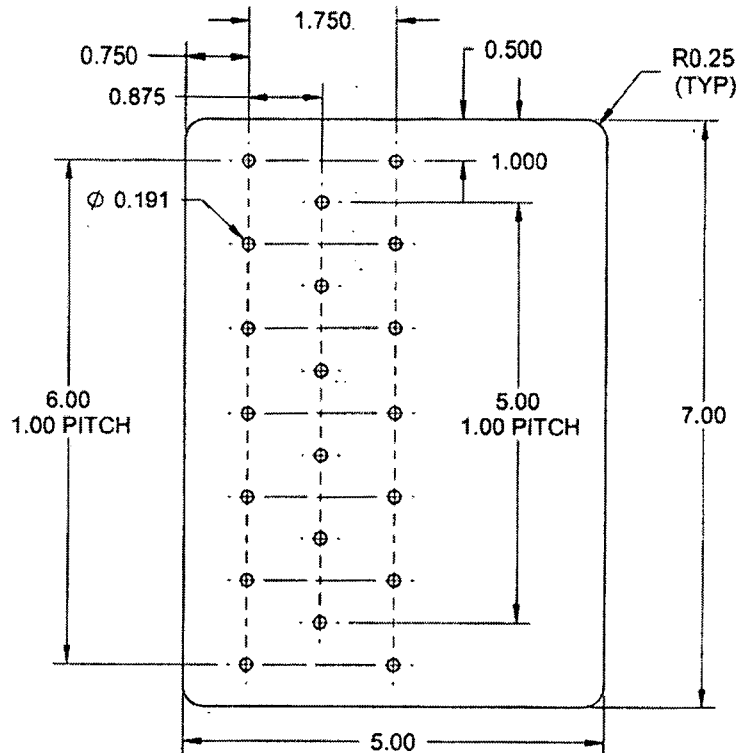
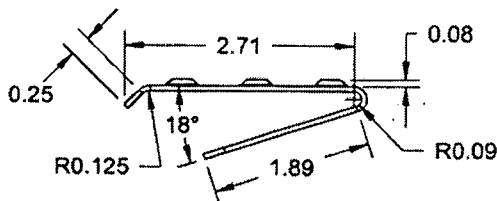
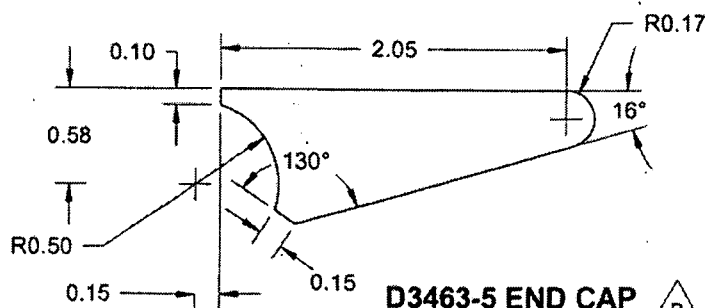
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

05.12.05 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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FIRST ARTICLE INSPECTION CHECKLIST


X

First Article

x

Prototype

[illegible]

Measured by:		Audited by:	J.G	Prototype Approval:	
Date:	06/09/05	Date:	06/09/05	Date:	NIA

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	